

Split

Work Order ID 84952-2

84952

Page 1

Item ID: D2855

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cap

Start Date: 29/05/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 170 82 Cast per Dwg D2855 Material Release Note
Required

100
100

12-05-30

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

12-05-30 100

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

100

12-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84952

May-29-12 1:14:47 PM

84952

Page 2

Item ID: D2855

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 29/05/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr

80
12-7-10 (10)

12.07.09

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/20/10

80
as per

150

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

0.00

10:00

9:30

80X

12/07/11

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

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Work Order ID 84952

May-29-12 1:14:47 PM

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Page 3

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N900040100

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Item Name: Cap

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50

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

x80 6 JH 12/07/11

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

✓ Install Inserts as per Dwg D2855

y80 6 JH 12/04/11

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

80 6 BH 12-7-11

W/O:		WORK ORDER CHANGES					
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Work Order ID 84952

May-29-12 1:14:47 PM

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Page 4

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Revision ID:

Item Name: Cap

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Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: 152-1

0.00

190

Packaging

Memo

0.00

Packaging

x80 k All 11/04/11

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

OK 12/7/12

12/207-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:14:51 PM

Page 1

Work Order ID: 84952

84952

Parent Item: D2855

D2855

Parent Item Name: Cap

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	1,075.000	2	100			
AI S7-1032-225 <i>✓</i> <i>Aug 4 1032-225 / 11122290</i>													
INSERT										<i>200</i>		<i>160</i>	

Location

Loc Qty

Loc Code

ST282

1075

100896

135

111529

27

118520

913

D2855P

Purchased

No

170

Each

0.0000

1

D2855P

Cap

50
100

160
all waste
1/24/12

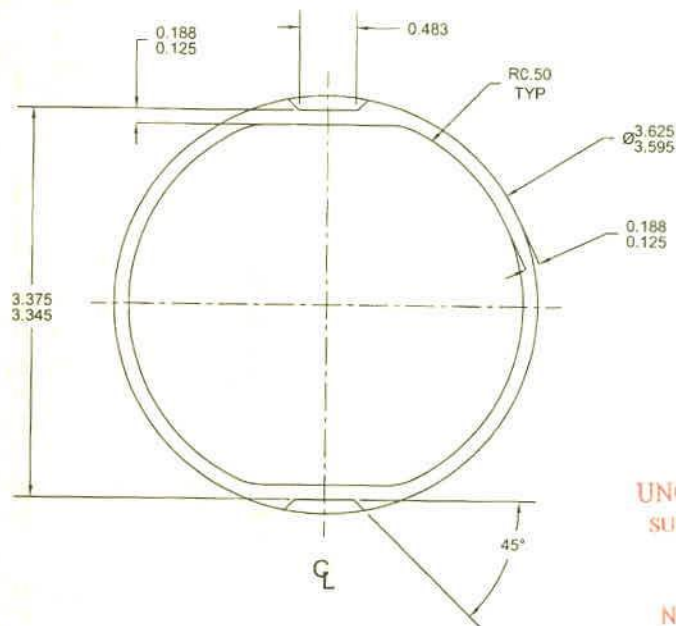
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

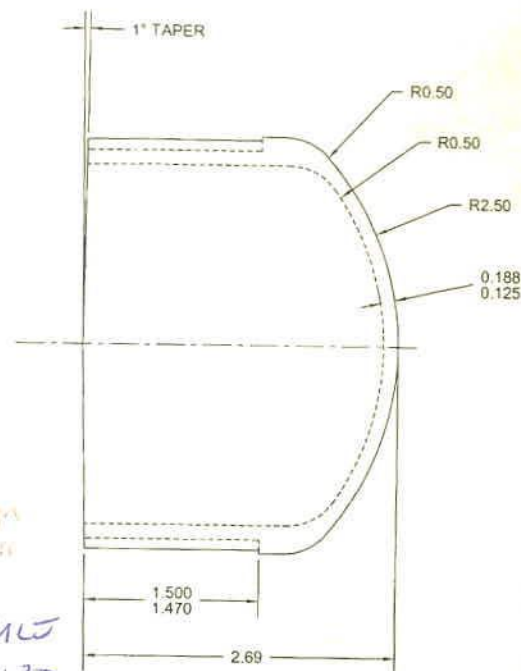
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84952 MLW
12/05/30



D2855C CASTING DETAIL



RELEASED
09/07/15 MLW

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)		RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)		DS	96.12.12
REV	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.	RF	D2855	SHEET 1 OF 3	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	CAP	NT	
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES OF WHICH IT WAS ISSUED AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

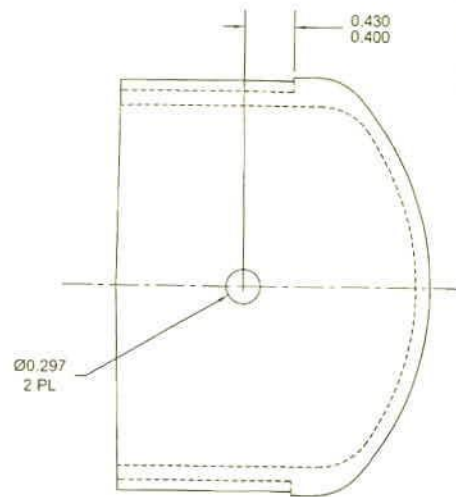
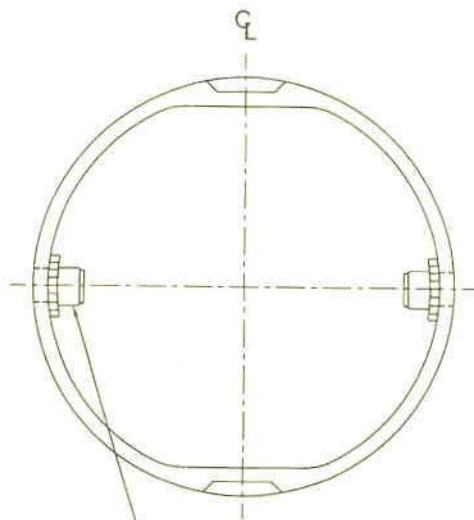
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

24952



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
31/5/19

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	MP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

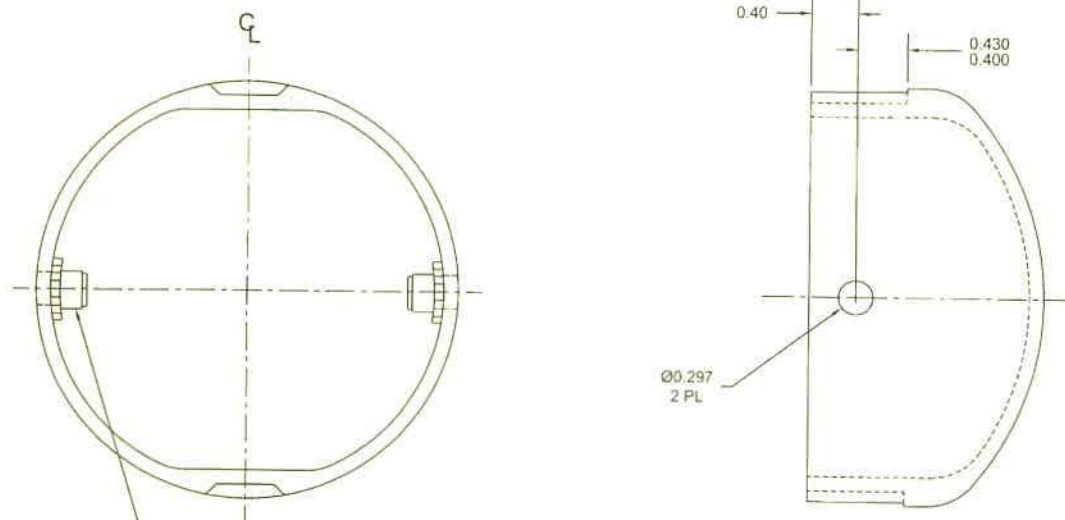
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

0-1952







INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
09/07/15 MB

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		CAP	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17082

Purchase Order Date 5/30/12

PO Print Date 5/31/12

Page Number 1 of 1

Order From:

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name

Vendor Phone

514 683 9777

Vendor Fax

514 683 0375

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	6/08/12 Yes	100.00 Each	Yours ppd	\$18.7000	\$1,870.00

Special Inst: As per DWG: D2855
Rev: B
B84952

PO Total: \$1,870.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - ☒ YES ☐ NO

Change Nbr: 3

Change Date: 5/31/12

Aluminum Foundry Ltd

2225 Chemin St. Francois

Dorval, Québec H9P 1K3

Tel: (514) 683-9777

Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

34078

Shipped Date:

14 06 2012

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel: (613) 632-5200 Fax: (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 17082	
Shipped By: Fedex	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	100
Received by:			
Date:			
Comment:			

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

2225 Chemin St. Francois, DORVAL, QC H9P-1K3
TEL: (514) 683-9777 FAX: (514) 683-0375

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **14/06/2011** Slip No. **34078**

Hawksbury, ON, K6A 1K7

Votre No. Commande **17082**
Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
100pcs	D 2855 CAP	Z098046	A356.2	B#1215801

Analyse
Analysis (as in Ingot C626-1819)

(Si)	7.10%	(Al)	balance
(Fe)	0.10%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.12%		

Donne
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100

